

Work Order ID 86396

86396

Page 1

June-27-12 4:08:15 PM

Item ID: D3929-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Gusset Assembly

Start Date: 27/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 12/06/28

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3929

Rev A

100

0.00

100

Waterjet

FLOW CNC Waterjet

304, 125"

Memo

1-Cut as per Dwg D3929

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

6 0 Jm 12-6-29

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

6 0 Jm 12-6-29

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120 QC Quality Control	Memo	0.00	8/26/13			(76)			
140		0.00							
140 Large Fab Large Fab	Memo	0.00				12-7-23			
	Weld bushings D3907-1 as per dwg D3929								
	316L rod batch 4131N 21602								
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
150 QC Quality Control	Memo	0.00				bx 12-7-23			DAS 24

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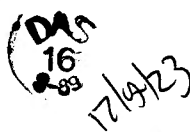



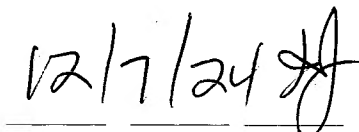

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00						12-07-23	
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: _____ Bucket call. Memo	0.00 0.00					12-07-23		
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

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Picklist Print

June-27-12 4:08:20 PM

Page 1

Work Order ID: 86396

86396

Parent Item: D3929-041

D3929-041

Parent Item Name: Gusset Assembly

Start Date: 27/06/2012

Required Date: 03/07/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S11GA

Purchased

No

100

sf

51.6260

0.45

2.842105

M304S11GA

304/316 0.125 Sheet

**

Jm 12-6-28

Location

Loc Qty

Loc Code

MAT020

51.626

121380

23.9

121780

27.726

121780

D3907-1

Manufactured

No

130

Each

3.0000

2

12

D3907-1

Bushing

**

CC 12-7-23

Location

Loc Qty

Loc Code

WA

82786

3

3

B86059 →

3x 9x

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Dart Aerospace Ltd

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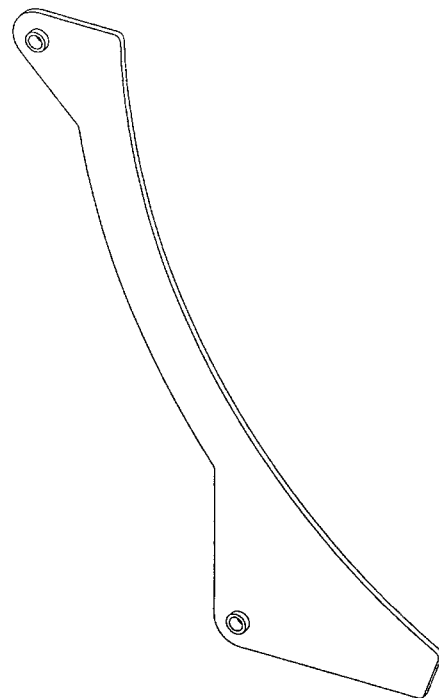
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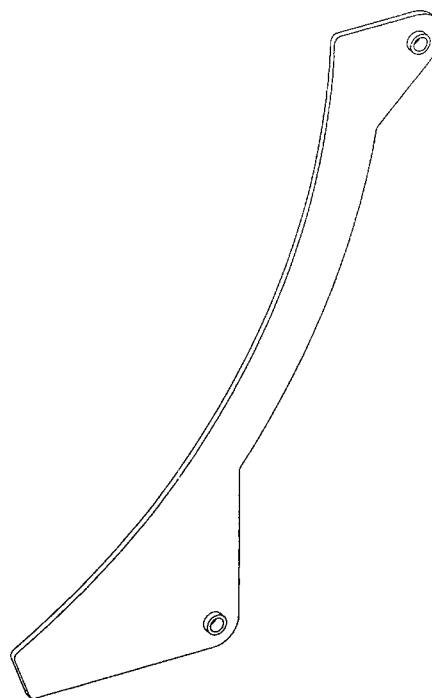
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ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 80396 MCV
12/06/28

RELEASED
9/04/28

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.73 lbs EACH
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	DESCRIPTION	MB	09.04.03
REV			BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR				
DATE	09.04.03			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3929** REV. A
SHEET 1 OF 3
TITLE **GUSSET ASSEMBLY** SCALE NTS

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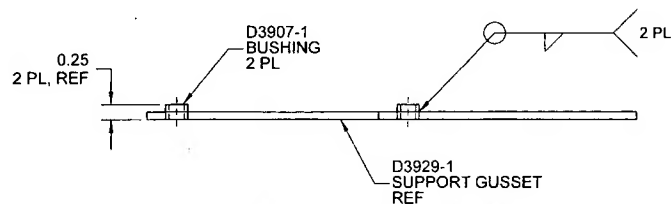
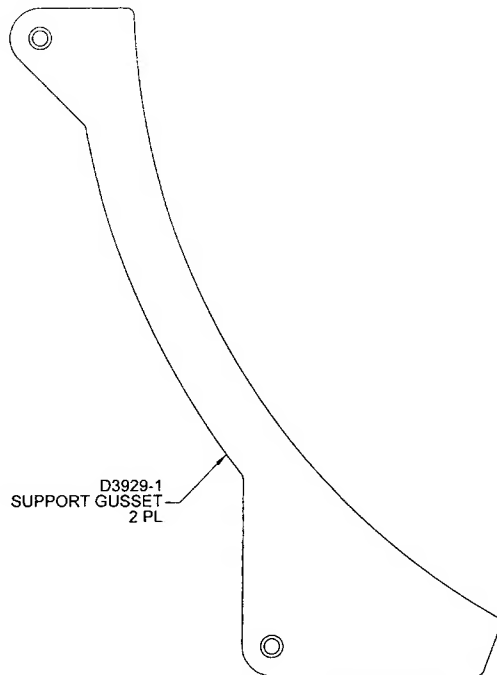
W/O:		WORK ORDER CHANGES					
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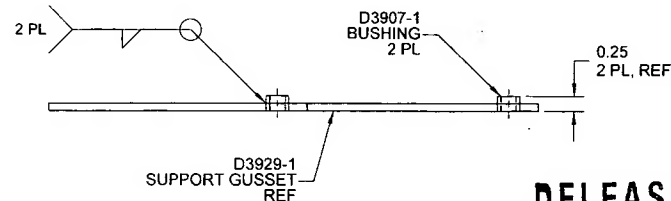
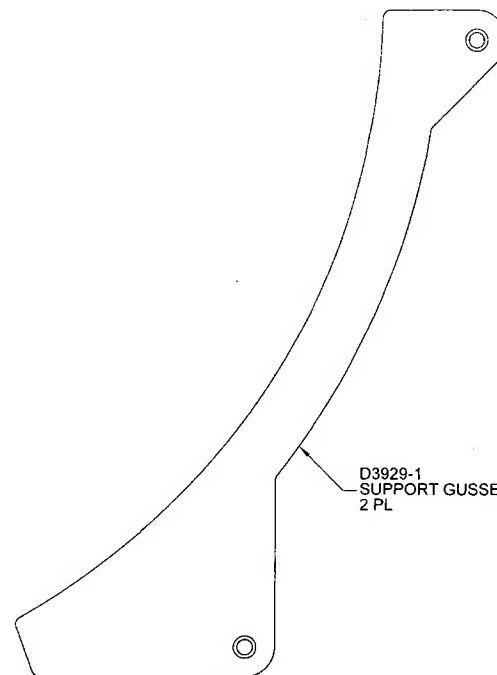
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D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

86396

RELEASED
09/04/22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3929	REV. A
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		GUSSET ASSEMBLY	SCALE
DE APPR.			NTS
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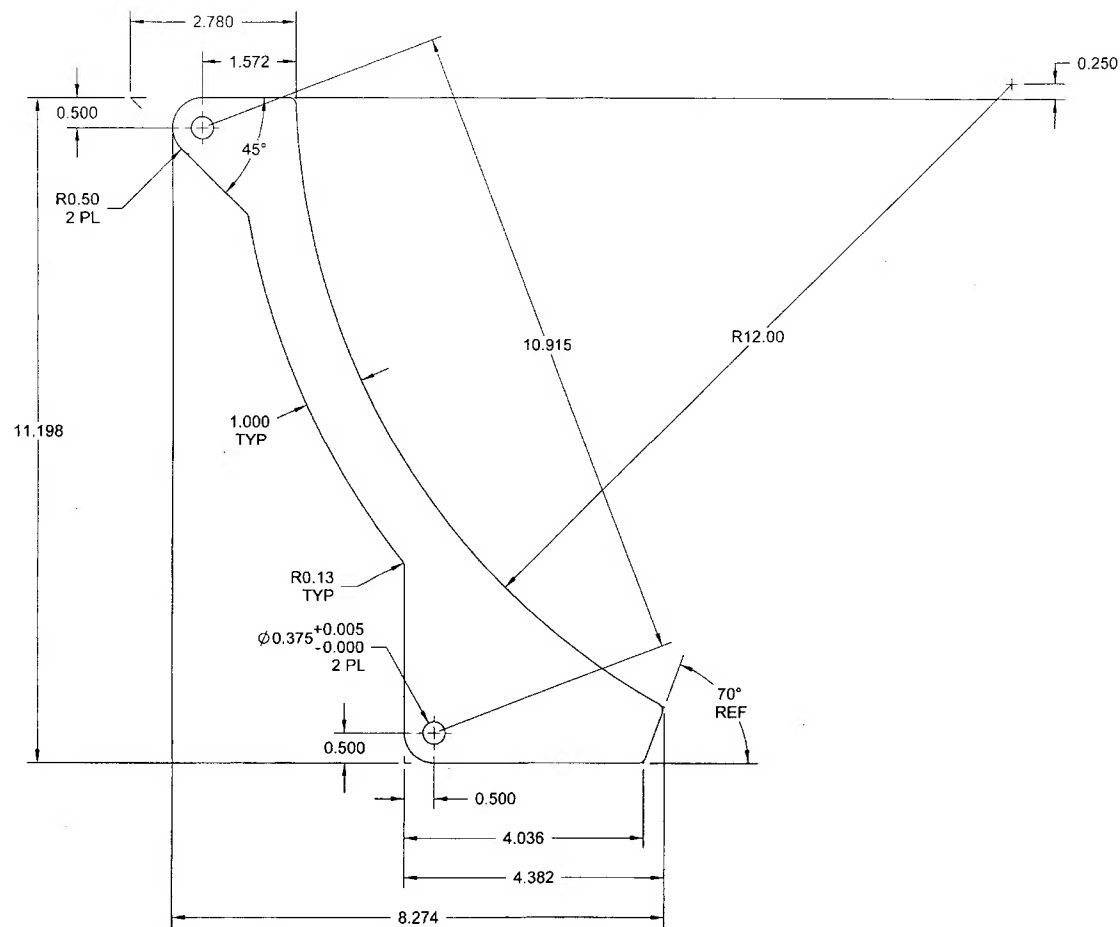
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D3929-1 SUPPORT GUSSET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

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MFG. APPR.		D3929	SHEET 3 OF 3
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08/04/22 HNB

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